

Date: Friday, 9/29/2006 10:42:59 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP WELDMENT
Job Number	: 28788		
Estimate Number	: 10176		
P.O. Number	: <i>N/A</i>	Part Number	: D2563
This Issue	: 9/29/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2563 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 27646	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/10/2006 Qty: 2 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est Rev:G 020731 Re-format Location RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2244116	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

1 D2244 Step Extrusion

Batch: *323404**PE 06.10.02*

2.0	D267334	End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2673-34	End Cap

Batch

*325396**(PE 06.10.03) + (2 extra for my test)**PE 06.10.02*

3.0	D2561	Lug Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2561	Lug Plate

Batch

*325461**(PE 06.10.03) + (1 extra for my test)**PE 06.10.02*

4.0	D2564	Mounting Angle
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part No.	Description
2	D2564	Mounting Angle

Batch

*327418**PE 06.10.02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:42:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 28788

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244 to 89.70" at 34° as per Dwg D2563

2-Deburr ends

3-Weld (1 End Only) as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M15689 M18612

4-Grind

LC. 06.10.02

2

LC. 06.10.02

2

LC. 06.10.03

2

LC. 06.10.03

2

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Job 10-11 (2)

AD 06/10/11 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC 06 10 14 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LC. 06.10.17

2

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Inspect for foreign object per QSI 024

2-Weld Remaining End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M18838 M19612

3-Grind

LC. 06.10.17

2

LC. 06.10.17

2

LC. 06.10.17

2

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Job 10-20

AD 06/10/18 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1 Date: 06/11/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:42:59 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 28788

Part Number: D2563

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch up Alodine then

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/11/07

(2)

a.m 06/11/07

(2)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2563 and QSI 005 4.4

M102098

a.m 06/11/09

(2)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/11/10

(2)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/13

Job Completion



C20611113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

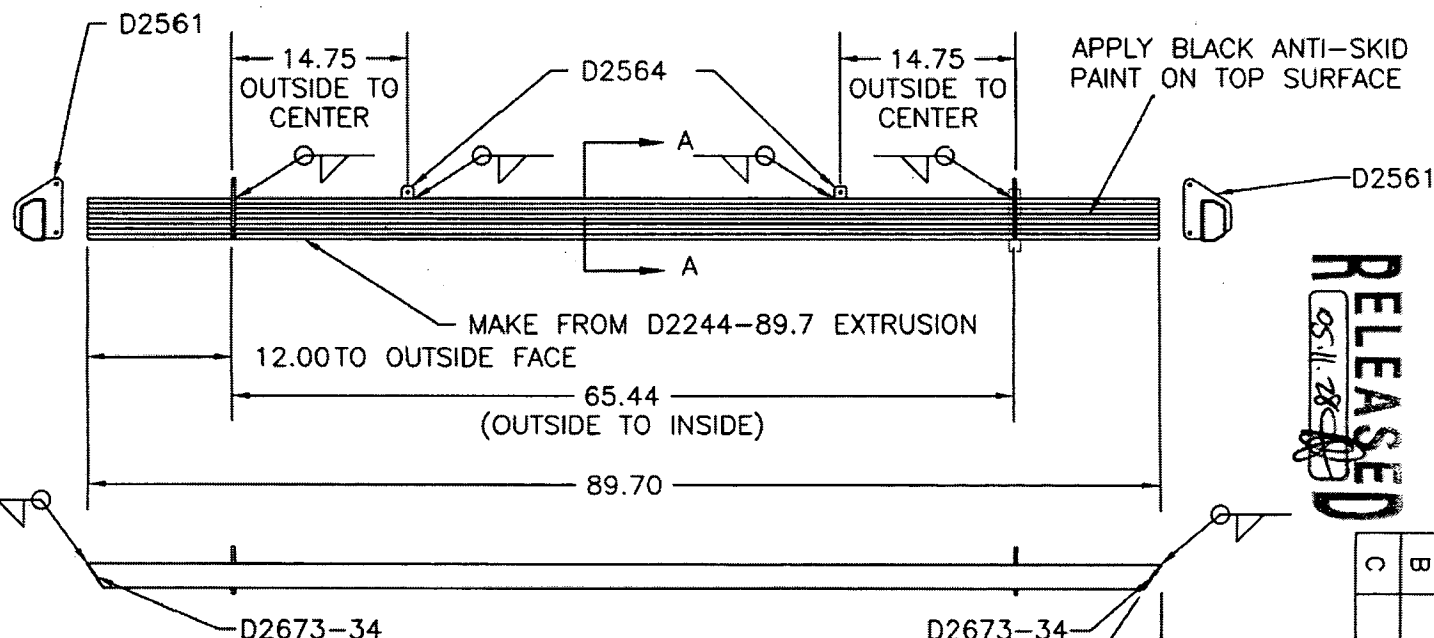
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
05.11.28



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
28788

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	47	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	TITLE	D2563	REV. C
		STEP WELDMENT ASSEMBLY		SHEET 1 OF 1
				SCALE 1:15
A	96.04.26	NEW ISSUE		
B	97.05.14	END CAPS CHANGED (WAS D2248)		
C	05.11.14	UPDATE NOTES		

Material Requisitions

R/S#: _____

Part Number: J2561

Batch Number: 324461

Quantity: 1

Required by: JE Date: 06.10.03

Used for

Part Number: J2563

Batch Number: B28788
~~B24461~~

Approved by Purchaser: _____

Date: _____

Comments: used for weld test

Material Requisitions

R/S#: _____

Part Number: D2673-34

Batch Number: 325396

Quantity: 2

Required by: LE Date: 06-10-03

Used for

Part Number: D2563

Batch Number: 328788
~~325396~~

Approved by Purchaser: _____

Date: _____

Comments:

used for weld test.

NO. 26

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Rat Ewers
Joint Welding Procedure TIG
Part number and Job number A2563 / B28788

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS _____
Penetration Complete ☐ Partial ☐ Single Weld ☐ Double Weld ☐
Current AC ☐ DC ☐ Backing YES ☐ NO ☐

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into _____ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐

Crossbolt Spacer Pass ☐ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/04 Qualifier [Signature]